

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001920**Date Inspected:** 04-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M, Orthotropic Box Girders (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 Deck Panel	NA	NA	QA UT
Storage Yard Outside New OBG Fabrication Bays - Caltrans QA Inspector performed Ultrasonic Test (UT) inspection of the partial joint penetration (PJP) welds joining closed u-ribs to deck panel. The deck panel is identified as DP488-001. Caltrans QA performed QA verification UT inspection on 15% of the full length of welds which have been previously UT inspected by ZPMC QC inspection personnel on the following weld joints: DP488-001-001, DP488-001-002, DP488-001-003, DP488-001-004, DP488-001-005 and DP488-001-006. See Caltrans ultrasonic testing report (TL-6027 Modified) dated April 04, 2008 for further information.			
2 Deck Panel	NA	NA	Welding
OBG Bay 1-Production Monitoring Deck Panel DP051-001- Caltrans QA Inspector observed submerged arc welding (SAW) in progress, closed u-rib sequence welding of welds 001 & 002, u-rib 111, welds 005 & 006, u-rib 114 and welds 009 & 010, u-rib 140. The SAW is being performed at Gantry 1. See Caltrans production deck panel welding record, which is being maintained on file at the on site OSM office for further information. The following digital photographs illustrate welding in progress at the work-station.			

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, (858) 334-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
